

slp 31/08

Date: Thursday, 8/30/2007 9:09:18 AM  
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HOUSING	<p>Per D2207 Rev.C PRELIM. 07.08.30</p>
Job Number : 34326		
Estimate Number : 11870		
P.O. Number : N/A	Part Number : D22071	
This Issue : 8/30/2007 S.O. No. : N/A	Drawing Number : D2207 UNDER REVIEW	
Prsht Rev. : NC	Project Number : N/A	
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : C	
Previous Run : 33240	Material : N/A	
Written By : <u>JD 07.08.30</u>	Due Date : 9/6/2007	Qty: 10 Um: Each
Checked & Approved By : <u>JD 07.08.30</u>		
Comment : Est. A 01.03.08 New Issue		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.4375 sf(s)/Unit Total : 4.3754 sf(s)

6061-T6 .063 Sheet

5052-H32 or 6061-T6 - .063" Thick

Batch M105225

SAD 07/08/30

2.0	SHEAR	SHEAR
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Comment: SHEAR

Shear blanks: 4.200" x 14.00" +.000"/-.030"

Grain along 14.00"

Dwg rev C

Prog rev C

SAD 07/08/30 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA031

Deburr

Dwg rev C

Prog rev C

SAD 07/08/30

10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/30

10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Er 07/08/30

counted

10

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/09/12	6	split into	SK	07/09/12	9		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: FD Date: 07/09/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/30/2007 9:09:18 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING

Job Number: 34326

Part Number: D22071

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend as per dwg D2207

SB 07/09/12

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/12 (49)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

07/09/17 (9)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207159/19

Job Completion



u 07/09/18

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	34326
<b>Description: Housing</b>		<b>Part Number:</b>	D2207-1
<b>Inspection Dwg: D2207</b>	<b>Rev: B</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

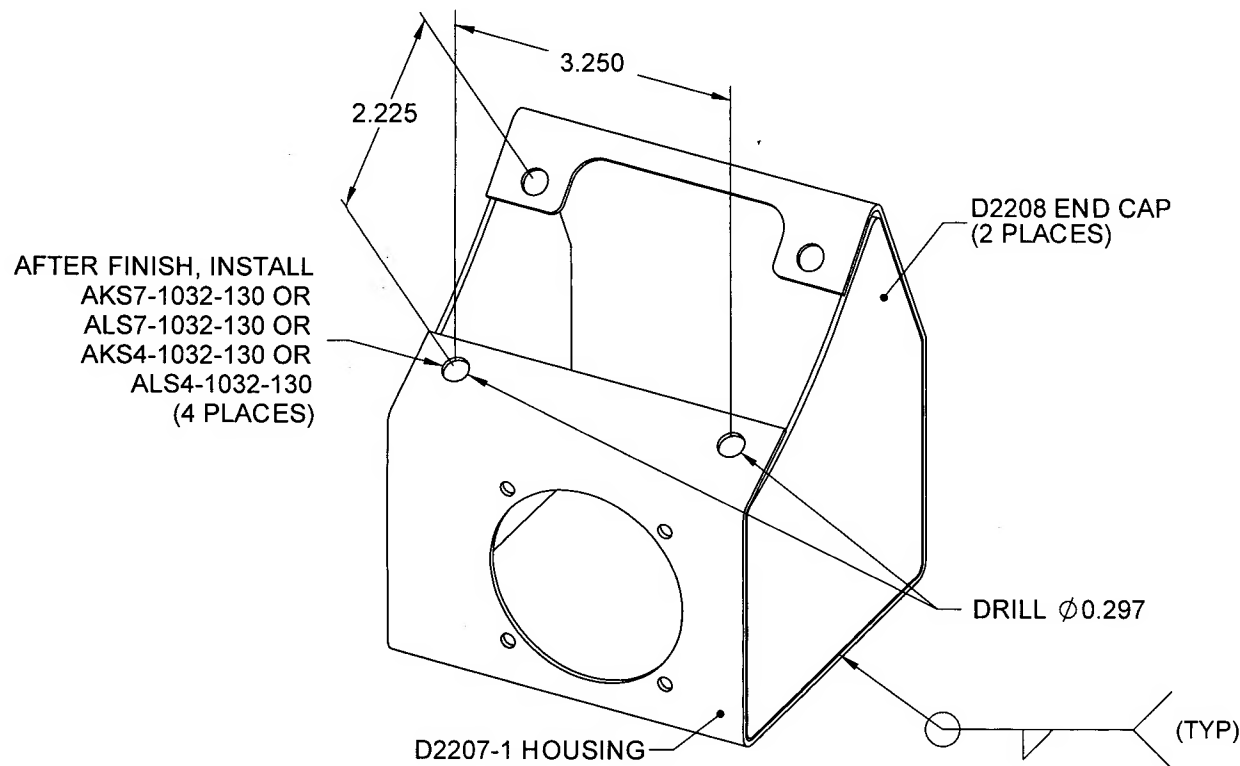
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.852	+/-0.010	0.851	✓		Vern	
R0.13	+/-0.030	R0.13	✓		R-G	
Ø0.166	+0.005/-0.000	0.166	✓		Vern	
11.630	+/-0.010	11.640	✓		Vern/Height gauge	
14.000	+/-0.010	14.063	✓		M-T	
0.923	+/-0.010	0.928	✓		Vern	
1.854	+/-0.005	1.853	✓		Vern	
1.854	+/-0.005	1.852	✓		Vern	
1.850	+/-0.010	1.853	✓		Vern	
Ø2.265	+0.005/-0.000	Ø2.265	✓		Vern	
4.200	+/-0.010	4.201	✓		Vern	
R0.300	+/-0.010	R0.300	✓		R-G	
Grain Direction	N/A		✓			
0.063	+/-0.010	0.059	✓		Vern	
Ø0.297	+0.006 -0.001	Ø0.298	✓		Vern	

<b>Measured by:</b>	SAD	<b>Audited by:</b>	En	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07/08/30	<b>Date:</b>	09/08/30	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	





### D2207-041 HOUSING ASSEMBLY

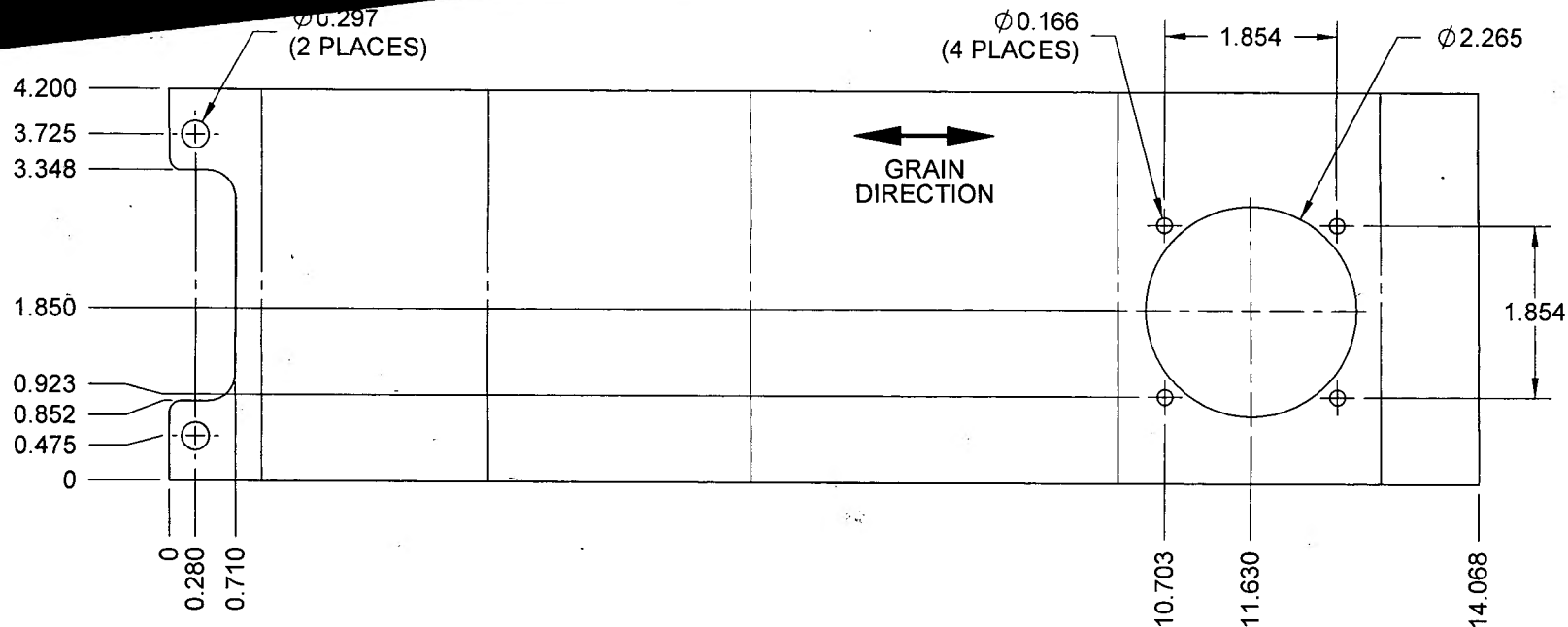
**PRELIMINARY ISSUE**

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WITHOUT NOTICE  
WORK ORDER  
NO. 34320

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>B</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>BE</i>	<b>D2207</b>	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>HOUSING</b>	1:2
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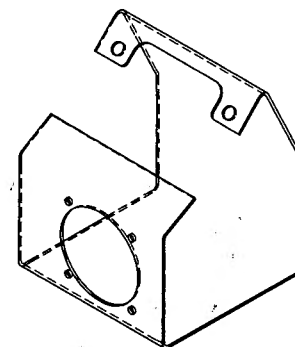


### D2207-1F FLAT PATTERN

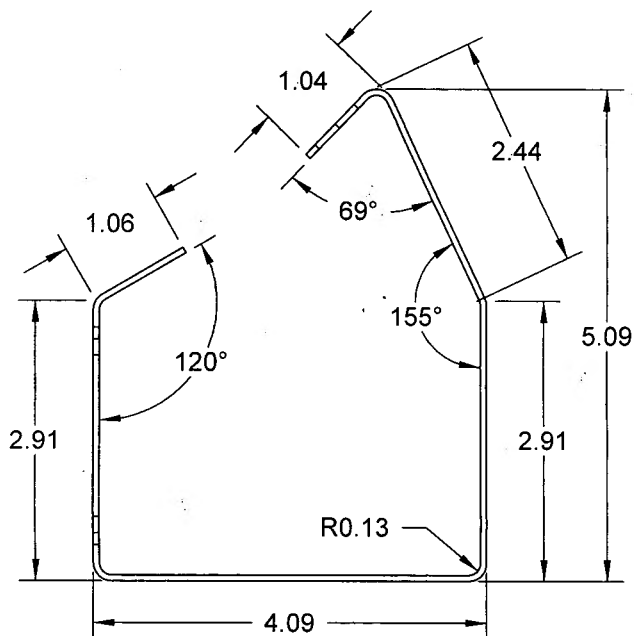
#### NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/8 OR AMS 4016  
(REF. DART SPEC. M5052H32S.063) OR  
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

**PRELIMINARY ISSUE**



**ISOMETRIC VIEW**  
(SCALE 1 : 4)



**D2207-1 BENDING DETAIL**

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WITHOUT NOTICE  
WORK ORDER  
NO. 34326

DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>B</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>EE</i>	<b>D2207</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>HOUSING</b>	1:2
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